

# Work Order ID 50499



Page 1

July 10, 2009 2:49:29 PM

Item ID: D3962-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rear Overhead Corner, RH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mc

Date: 09-07-10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3962

A-PROTO 09-06-18

100

0.00



HandThermo

Memo

0.00

HandFinishing Thermoforming

1-Cut Sheet to required Blank size

BB 09/07/13 (X1)

M109703

110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up  
2-Pre-heat Tool to required temp.  
3-Thermoform as per Dwg and Folio #FTA062 using tool DT9342  
Dwg Rev: A  
Folio Rev: A

BB 09/07/13 (X1)



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Page 2

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Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

BB 09/07/16 XI

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

WH 09/07/14 XI

140

Hand Thermo

0.00



Hand Thermo

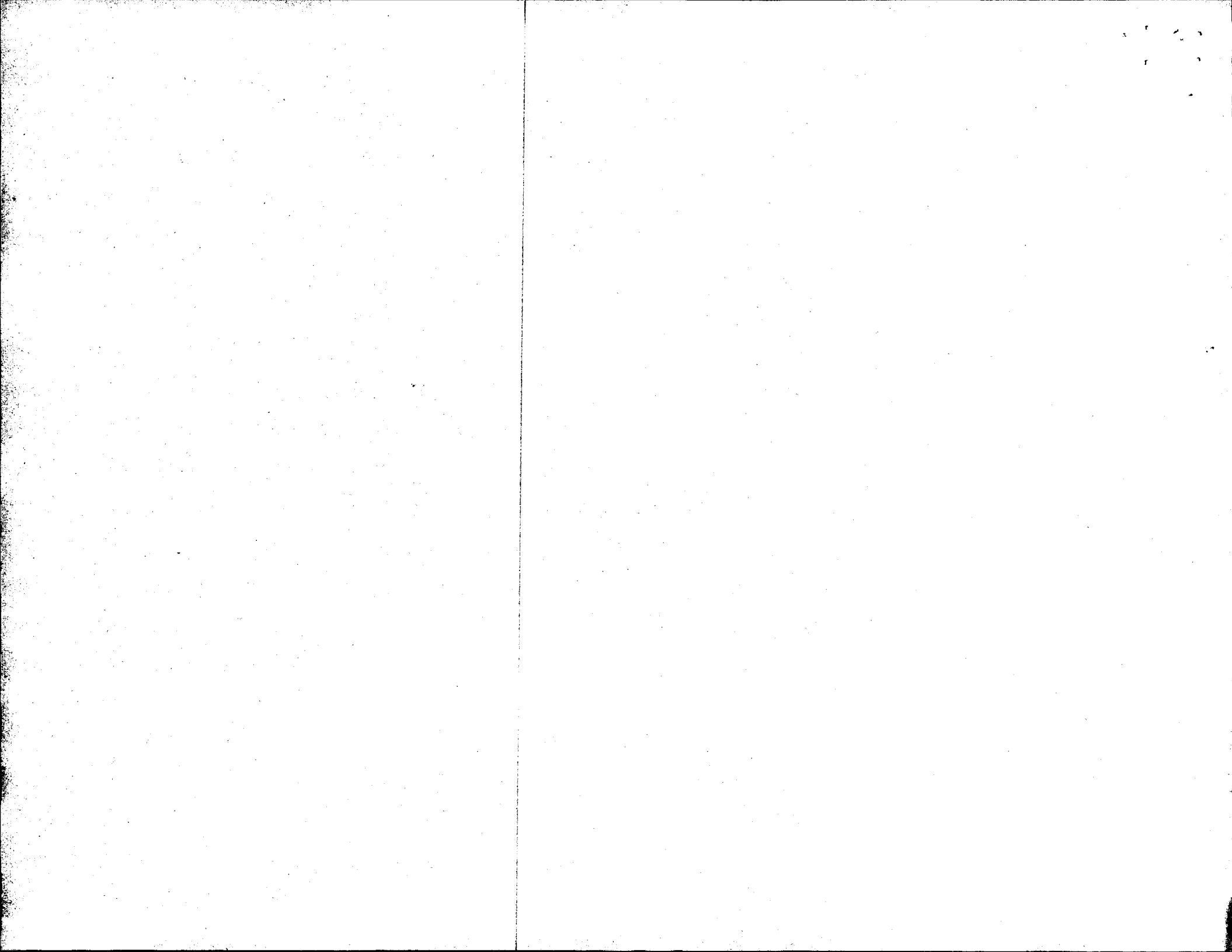
Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

WH 09/07/14 XI



# Work Order ID 50499

July 10, 2009 2:49:29 PM

Page 3

Item ID: D3962-2KIV

Accept

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Item Name: Rear Overhead Corner, RH

Start Date: 07/13/2009 Start Qty: 1.00

Required Date: 07/17/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

Complete FAI document

07/09/14 (21)

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

RA 09-07-20  
ENGINEERING APPROVAL

170

Identify as per dwg & Stock Location:

0.00

Packaging

Memo

0.00

Packaging

FORC ENG'S TEST  
RA 09-07-20



**Work Order ID 50499**

Page 4

July 10, 2009 2:49:29 PM

Item ID: D3962-2KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Rear Overhead Corner, RH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

H.09.07.20 Prototype

WBS 24-0709





# Picklist Print

Page 1

July 10, 2009 2:49:29 PM

Work Order ID: 50499

Parent Item: D3962-2KIVRevA-PROTO

Parent Item Name: Rear Overhead Corner, RH

Comments:

Start Date: 07/13/2009

Required Date: 07/17/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	1.0000			



6185 KYDEX .080"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

894.5037653

109703

894.503765

M109703 BB 07/07/09



DART AEROSPACE LTD	Work Order: 50498.
Description:	Part Number: D3962-2K1V
Inspection Dwg: D3962-2, Rev: A. PROTO	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/16

#### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.7"	$\pm .100$	1.75"	✓			
1.6"	$\pm .100$	1.625"	✓			
11.5"	$\pm .100$	11.5"	✓			
1.6"	$\pm .100$	1.625"	✓			
13.5"	$\pm .100$	13.5"	✓			
0.050"	$\pm .030$	0.052"	✓			
0.035	MIN	0.040	✓			

Measured by: W. Legu.

Date: 09/07/14

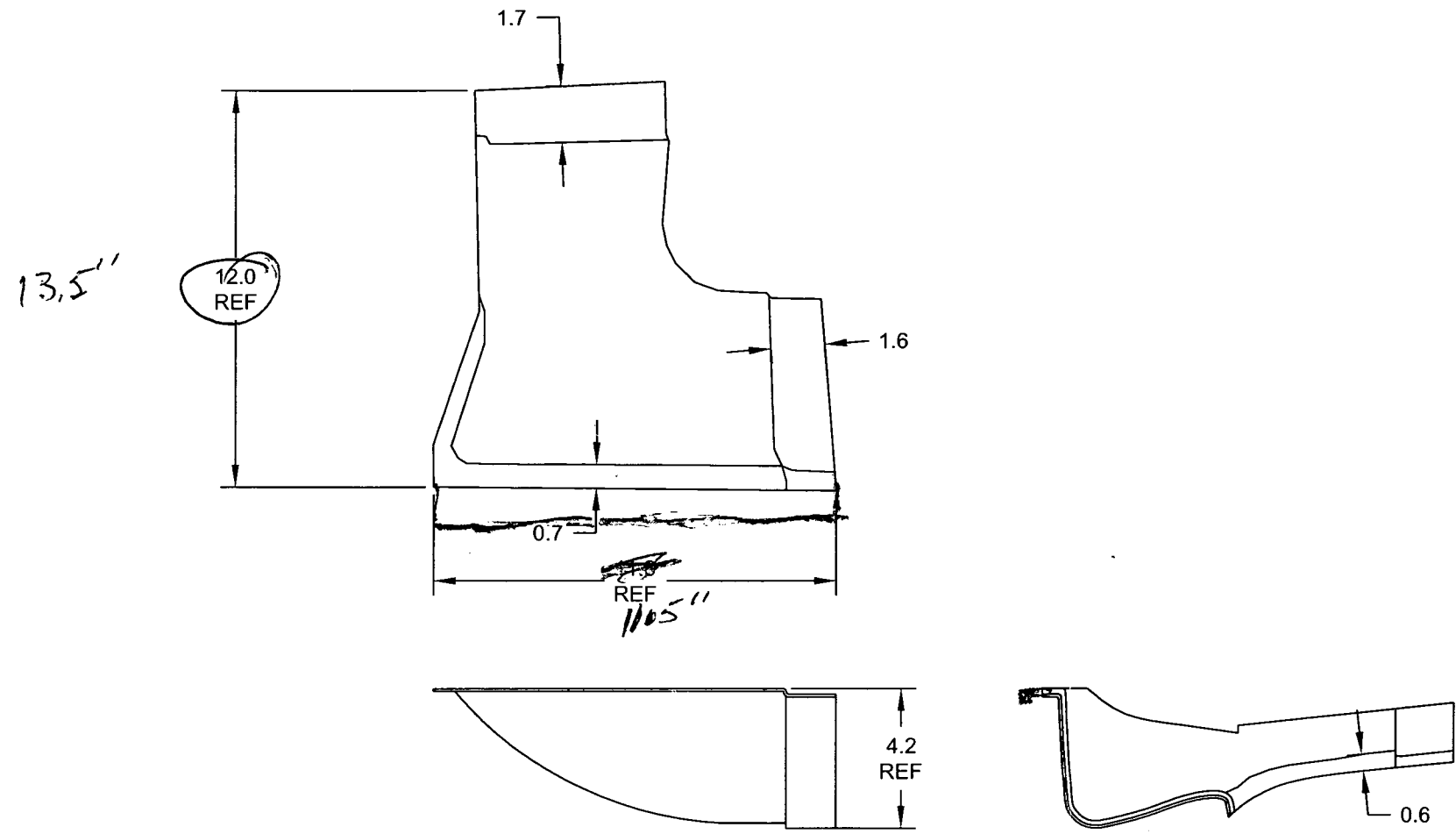
Audited by: PH

Date: 09.07.17

Prototype Approval: PH

Date: 09.07.17

Rev	Date	Change	Revised by	Approved:
A		New Issue	KJ/DL	



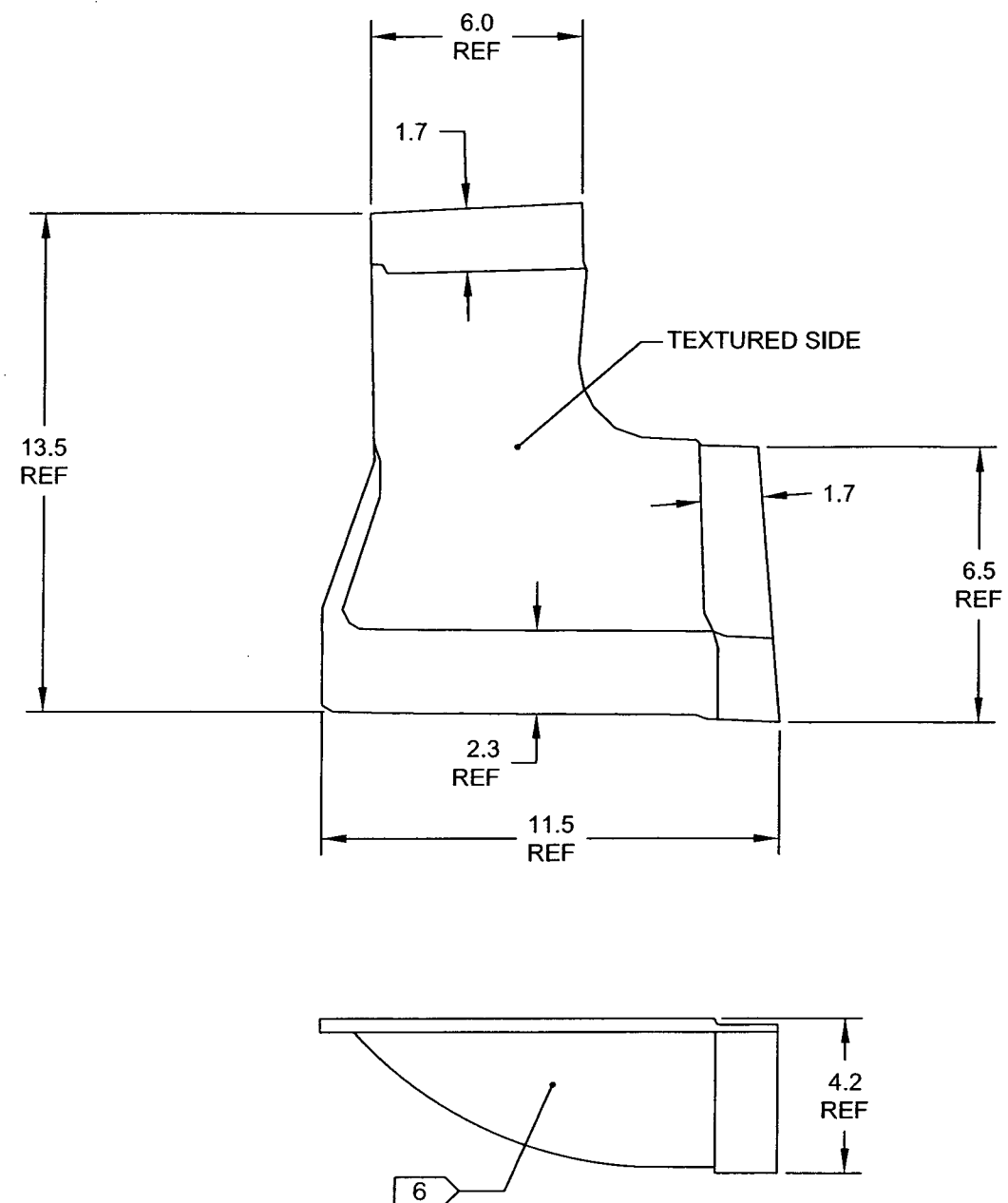
**D3962-2 REAR OVERHEAD CORNER, RH**

**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09-07-03 PB

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 0.4 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9072 PER DART QSI 022. TRIM PER MOLD
  - 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3962	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REAR OVERHEAD CORNER (206 L3/L4) NTS	
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**D3962-2 REAR OVERHEAD CORNER, RH**

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.45 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9342 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.035" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3962-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3962-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	<i>RH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>RH</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3962	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	REAR OVERHEAD CORNER (206 L3/L4)	NTS
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